

Work Order ID 83349

Tuesday, April 17, 2012 1:46:58 PM

83349

Page 1

Item ID: D3955-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler Assembly

Start Date: 4/17/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/20/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *12-04-15* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3955	A

100	0.00
-----	------

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3955-1

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

110	0.00
-----	------

QC2- Inspect parts off machine FAI/FAIB

110

QC

Memo

0.00

Quality Control

ASAP

B12-4-17

13

B12-4-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83349***83349***

Page 2

Tuesday, April 17, 2012 1:46:58 PM

Item ID: D3955-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler Assembly

Start Date: 4/17/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/20/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Small Fab

Memo

0.00

Small Fab

1- C'sink holes as per dwg

2- Deburr if necessary

140

0.00

140

QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

Sitzler

(13)

13x ϕ 4/20/12

Sitzler

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83349

83349

Page 3

Tuesday, April 17, 2012 1:46:58 PM

Item ID: D3955-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler Assembly

Start Date: 4/17/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/20/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Run Start ***NR1***

Stop ***NR2***

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

(13) 12-4-18 ll 12-04-18

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

13 0 BL 12-4-18

170

Pick Kit

0.00

170

Packaging

Memo

0.00

Packaging

13 0 12/04/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83349

83349

Page 4

Tuesday, April 17, 2012 1:46:58 PM

Item ID: D3955-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler Assembly

Start Date: 4/17/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/20/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

0.00

180

Small Fab

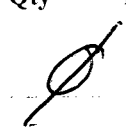
Memo

0.00

Small Fab

1- Assemble nut plate as per dwg

13x



12/04/18

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

Scrubber

13

200

Identify as per dwg & Stock Location: 76

0.00

200

Packaging

Memo

0.00

Packaging

13x

12/4/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83349

83349

Page 5

Tuesday, April 17, 2012 1:46:58 PM

Item ID: D3955-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler Assembly

Start Date: 4/17/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/20/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/4/19

Mr
12-04-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 17, 2012 1:46:58 PM

Page 1

Work Order ID: 83349
Parent Item: D3955-041
Parent Item Name: Doubler Assembly

Start Date: 4/17/2012 Required Date: 4/20/2012
Start Qty: 12.00 Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	292.8422	0.3553	4.488			

B12-4-17

Location	Loc Qty	Loc Code
MAT021	292.8422000	
113608	0	
116308	6.01556842	
117285	67.544	
119331	45.2	
119802	20.94	
120218	26	
120866	127.142632	

MS21086L3 Nut Plate	Purchased	No			180	Each	16.0000	1	12			
------------------------	-----------	----	--	--	-----	------	---------	---	----	--	--	--

Location	Loc Qty	Loc Code
ST303	16	
117519	16	

MS20427M3-3 Rivet	Purchased	No			180	Each	2,031.0000	2	24			
----------------------	-----------	----	--	--	-----	------	------------	---	----	--	--	--

Location	Loc Qty	Loc Code
GA	1649	
121114	1649	
ST318	382	
118384	82	
120930	100	
121350	200	

120218

13

26

13

4/12/04/18

4/12/04/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

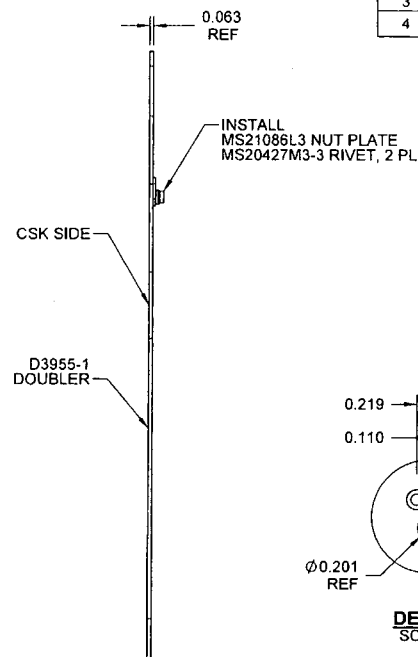
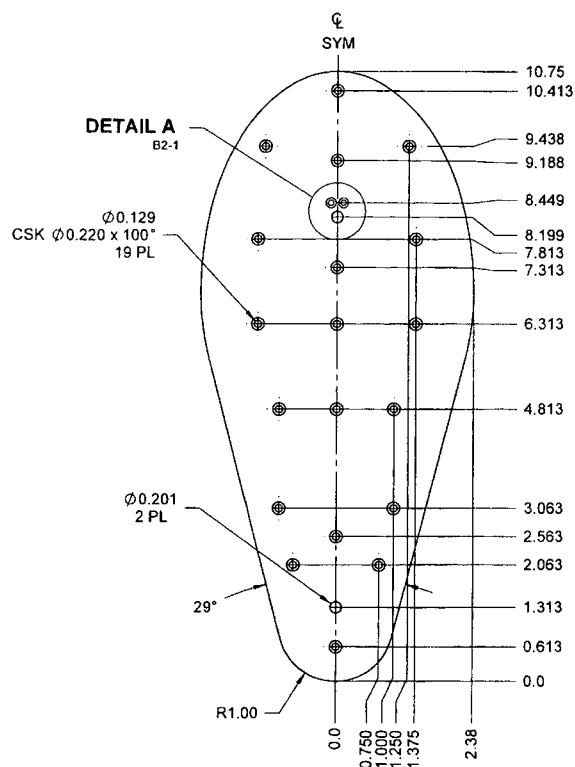
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

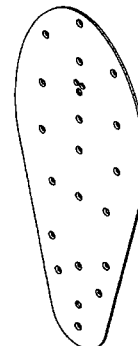
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET



#83349



D3955-1 DOUBLER

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

D3955-041 DOUBLER ASSEMBLY

RELEASED
09/07/21

A NEW ISSUE		RF 09.07.21	
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
DATE	09.07.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	83349
Description: Doubler		Part Number:	D3955-1
Inspection Dwg: D3955	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.132	2		V BL	
Ø0.201	+0.005/-0.001	.204	2		V	
0.750	+/-0.010	.753	2		V	
1.000	+/-0.010	1.000	2		V	
1.250	+/-0.010	1.250	2		V	
1.375	+/-0.010	1.370	2		V	
2.38	+/-0.030	2.381	2		V	
0.613	+/-0.010	.609	2		V	
1.313	+/-0.010	1.310	2		V	
2.063	+/-0.010	2.059	2		V	
2.563	+/-0.010	2.560	2		V	
3.063	+/-0.010	3.063	2		V	
4.813	+/-0.010	4.807	2		V	
6.313	+/-0.010	6.313	2		V	
7.313	+/-0.010	7.309	2		V	
7.813	+/-0.010	7.804	2		V	
8.199	+/-0.010	8.199	2		P Rensur	
8.449	+/-0.010	8.442	2		P	
9.188	+/-0.010	9.180	2		P	
9.438	+/-0.010	9.429	2		P	
10.413	+/-0.010	10.415	2		P	
10.75	+/-0.030	10.753	2		P	
0.063	+/-0.010	.064	2		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 12-4-17	Date: 12/4/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue P/O D3955-041	KJ	AS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries